

CLAIMS:

1. A method of producing a structural beam with openings located in the web, which comprises the steps of taking a universal beam, making a cut generally longitudinally along the web thereof, making a second cut along the web on a path differing from the first path of the first cut, separating the cut halves of the beam, and welding the halves together,
5 characterised in that:

a width of material or ribbon is defined by the two cuts of an amount equal to the desired reduction in depth of the finished cellular beam.

2. A method according to claim 1, wherein the depth of the finished cellular beam is less
10 than that of the universal beam from which it is produced.

3. A method according to claim 1 or 2, wherein the cut along the web can be such that any shape of openings can be obtained.

4. A method according to any preceding claim, wherein the cut along the web can be such that any position of openings can be obtained.

5. A method according to any preceding claim, wherein the beams are separated and
15 moved longitudinally relative to one another before being welded together.

6. A method according to any of claims 1 to 4, wherein the two halves of the beam are not moved longitudinally relative to one another before welding.

7. A method according to claim 1, wherein two or more universal beams are cut and
20 separated into halves and the halves from different cut universal beams are used to produce asymmetrical cellular beams.

8. A structural beam when prepared by any of the method claims 1 to 7.